

Date: Monday, 3/13/2006 7:29:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (EC 135)
Job Number	: 26199		
Estimate Number	: 10536		
P.O. Number	: N/A	Part Number	: D135692011
This Issue	: 3/13/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3049 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25164	Drawing Revision	: A1
		Material	: N/A
		Due Date	: 3/20/2006
Written By	: <u>SEE COMMENT BELOW</u>	Qty:	5 Um: Each
Checked & Approved By	: <u>06.03.13</u>		
Comment	: Est Rev:C 0402.17 Blank size changed, Tolerance added Step 3 KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 5.4810 sf(s)/Unit Total : 27.4050 sf(s)
 blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)
 per DSK086-9
 Material: Black UHMW 1"(MUHMWB10)
 Batch: ~~M19541~~ M19541

Jmf 06/03/20
Jmf 06/03/25

KJW

5

5

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

Jmf 06/03/20
J.F. 06/03/22

5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF / Jmf 06/03/20

5

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 06.03.22

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:29:27 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 26199

Part Number: D135692011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

6.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.5000 f(s)/Unit Total : 2.5000 f(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D2182B060	Rubber Cushion	B23172 ✓
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7.0	D2274	Radius Block
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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8	D2274	Radius Block	B25223 ✓
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8.0	D2519	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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4	D2519	Clamp	B18892 ✓
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9.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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8	D2529	Washer	B25372 ✓
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10.0	AN415A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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8	AN4-15A	Bolt	M17544 M19085 ✓
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14 mlt

26 mlt

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 26/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:29:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 26199

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M19085 ✓

12.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M19099 ✓

13.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3049-1(ref) Bearpaw B26199

4 QS100M24S Clamp M19214 14 mep 6 mcs

1 Paperwork package from Step 2(ref)

M100622
04/3/22 (5)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206104104 (3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev:

C 06/4/10 5

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/11 (5)
u 06/04/11

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26199
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	Ø0.260	—			
B	0.93	+/-0.030	0.929	—			
C	0.40	+0.030/-0.000	0.408	—			
D	2.00	+/-0.030	2.000	—			
E	10.250	+/-0.010	10.250	—			
F	4.540	+/-0.030	4.540	—			
G	5.88	+/-0.030	5.876	—			
H	0.38	+/-0.030	0.376	—			
I	15.50	+/-0.030	15.50	—			
J	0.07 x 45°	+0.030/-0.010	0.068	—			
K	0.44 – 0.47	+/-0.000	0.450	—			
L	R0.25	+/-0.030	R0.25	—			
M	0.38	+/-0.010	0.384	—			
N	0.95	+0.030/-0.010	0.945	—			
O	0.69	+/-0.030	0.706	—			
P	0.20	+/-0.030	0.188	—			
Q	23.00	+/-0.030	23.00	—			
R	0.25 x 45°	+/-0.030	0.25x45°	—			

Measured by:	JML	Audited by:	Er	Prototype Approval:	N/A
Date:	06/03/20	Date:	06/03/20	Date:	N/A

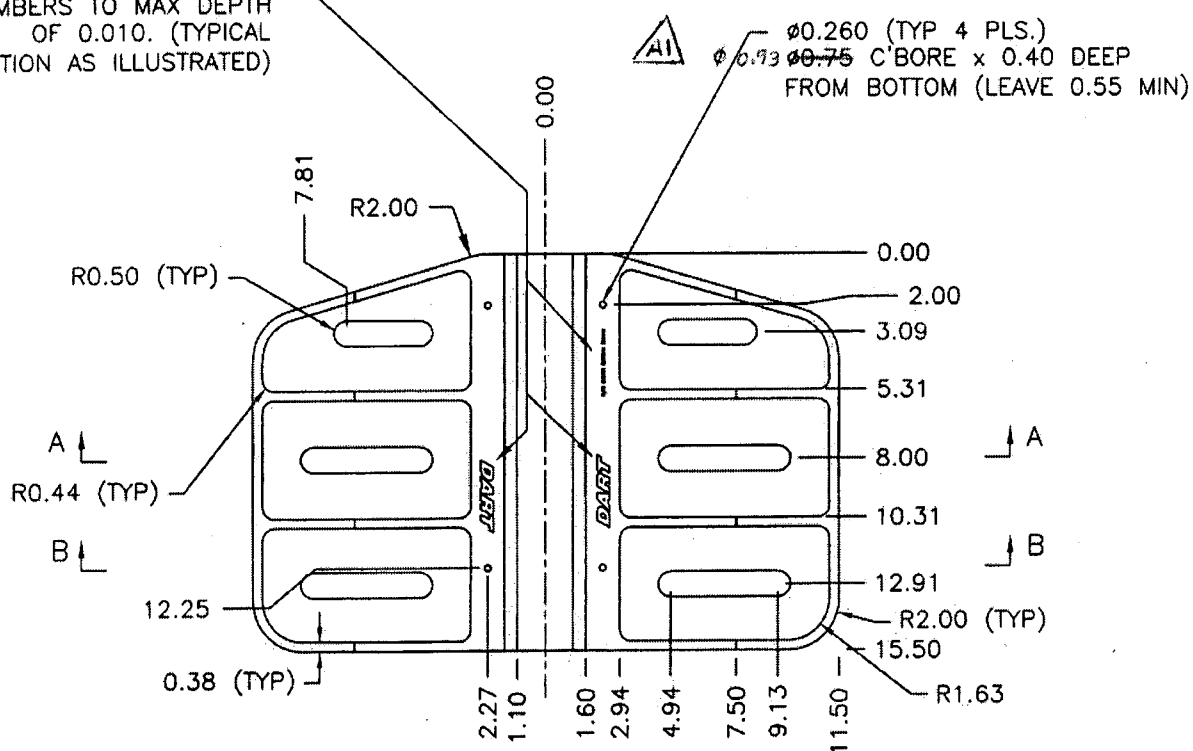
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	✱



DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D3049 REV. A SHEET 1 OF 2	
DATE 01.10.18		TITLE BEARPAW		SCALE 1:7	
A	01.10.18		NEW ISSUE		
AI	[Signature] 03.01.13		ø 0.73 WAS ø 0.75		

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL
1.00" THICK (MACHINE TO 0.950)

ENGINEERING
DRAWING D2689, UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26199

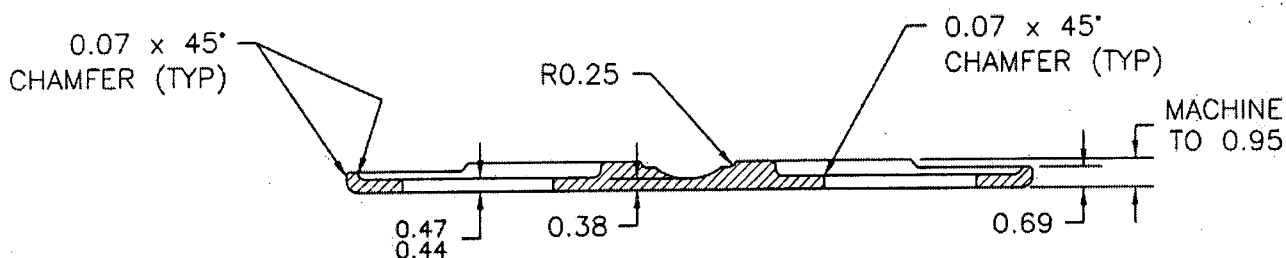
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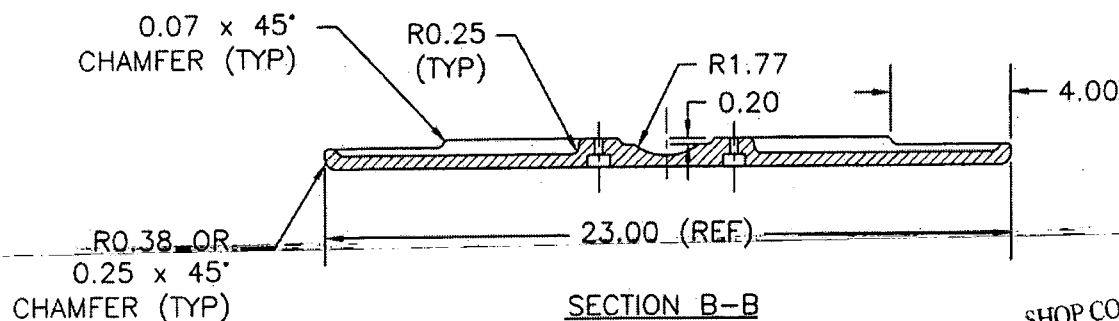


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26199

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